SHIM PRELIMINARY ISSUE 9.10.09

Work Order ID 61969-2

Monday, September 13, 2010 11:16:41 AM

Item ID: D4173-7
Revision ID: PRELIM
Item Name: Radalt Shim

Accept

Setup Start

Stop

Start Date: 9/13/2010 **Start Qty:** 2.00
Required Date: 9/20/2010 **Req'd Qty:** 2.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** ✓ **Date:** 9-9-13 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4173	Revision Nbr: ~~PA1~~ PA2 9.10.09.								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT AS PER DWG PROG REV: PA2 DWG REV: ~~PA1~~ PA2 DEBURR								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

IB 10-9-14

IB 10-9-14

Pho

Work Order ID 61969

Monday, September 13, 2010 11:16:41 AM

Item ID: D4173-7
Revision ID: PRELIM
Item Name: Radalt Shim

Start Date: 9/13/2010 **Start Qty:** 2.00
Required Date: 9/20/2010 **Req'd Qty:** 2.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA 961 FOLIO REV: AA DWG REV: Rad DEBURR								
130	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00 – inspected to PA2 Dwg only 8 10/2/15 (x2)							
QC	**Memo**	0.00							
Quality Control									

10.09.15

10.09.15

Work Order ID 61969

Monday, September 13, 2010 11:16:41 AM

Item ID: D4173-7
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Start Date: 9/13/2010 **Start Qty:** 2.00
Required Date: 9/20/2010 **Req'd Qty:** 2.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location Completes	0.00				
Packaging						
Packaging	**Memo**	0.00				
160	QC21- Final Inspection - Work Order Release	0.00				
QC						
Quality Control	**Memo**	0.00				

ZT 10-10-01

10/10/04 DJ

DJ 10-10-01

POSITIVE RECALL
EFFECTIVE 10.9.13 AUTH
RELEASED DATE 10.10.01
Per Released Date
Dated 10.04.29

Picklist Print

Monday, September 13, 2010 11:16:45 AM

Work Order ID: 61969

Parent Item: D4173-7

Parent Item Name: Radalt Shim

Start Date: 9/13/2010 **Required Date:** 9/20/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A NEW ISSUE 10-09-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB625		Purchased	No			100	sf	9.0000	0.5	1.052632			
UHMW .625 Black Tivar 1000													

Location	Loc Qty	Loc Code
MAT	9	
109313	9	

IR 10-9-13

109313

(2)

DART AEROSPACE LTD	Work Order:	61969
Description: RABBIT SHIM	Part Number:	D4173-7
Inspection Dwg: D4173-7 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

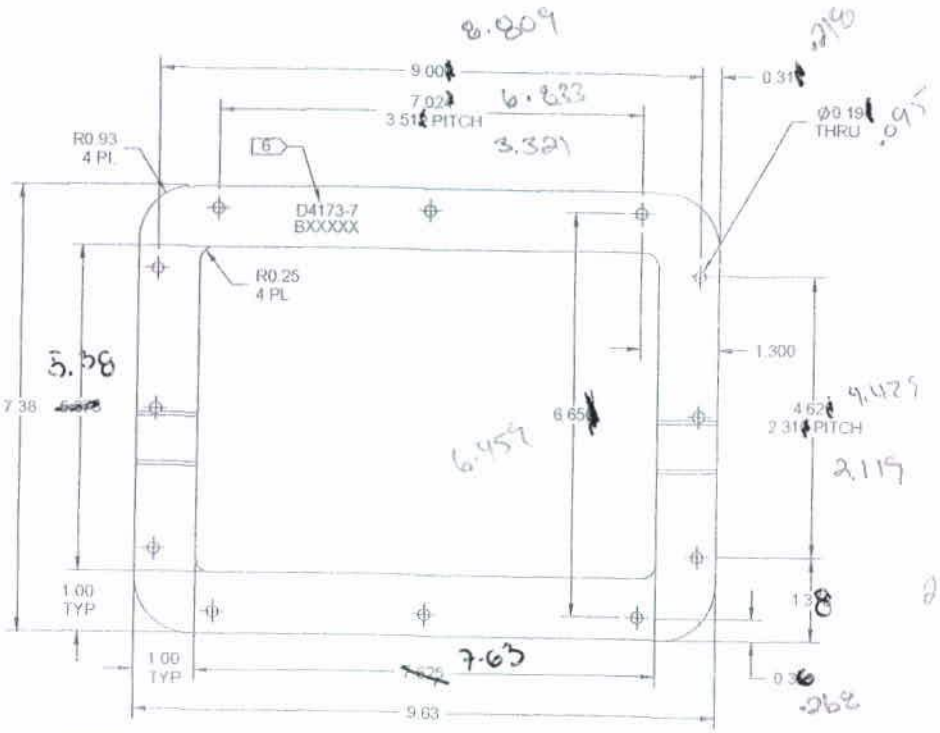
[X] First Article [ ] Prototype

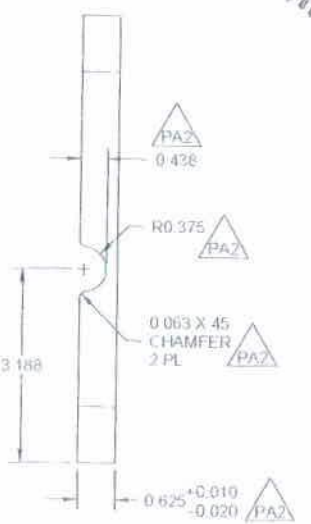
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .191	+.005 -.001	.193	X			
9.000	+/- ~~.010~~ 0.030	9.004	X			
7.074	+/- ~~.010~~ 0.030	7.077	X			
3.512	+/- ~~.010~~ .030	3.510	X			
.313	+/- ~~.010~~ .030	.315	X			
1.300	+/- ~~.010~~ .030	1.304	X			
4.620	+/- ~~.010~~ .030	4.618	X			
2.310	+/- ~~.010~~ .030	2.313	X			
1.378	+/- ~~.010~~ .030	1.383	X			
.363	+/- ~~.010~~ .030	.368	X			
9.63	+/- .030	9.635	X			
7.625	+/- ~~.010~~ .030	7.615	X			
1.00	+/- .030	1.010	X			
5.374	+/- ~~.010~~ .030	5.373	X			
7.38	+/- .030	7.386	X			
.617	~~+/- .010~~ +.010 -.020	.607-.628	✓			
.438	~~.375 +/-.010~~	.438	✓			
R.750	+/- .010	R.750	✓			

Measured by:	[signature]	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-14	Date:	10/09/14	Date:	N/A

Updated to PAD Dwg only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





PRELIMINARY ISSUE

D4173-7 RADALT SCHIM PA2

ALL DIMS OK WITH 2 DEC. PL.

10.09.15

PRELIMINARY ISSUE
10.09.15

NOTES:
1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF: DART SPEC: MUHMWB
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.4
7) WEIGHT: 0.76 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO: D4173 REV: PA2
MFG. APPR		SHEET 7 OF 7
APPROVED		TITLE: POD RADALT MOUNTING PLATE ASSY SCALE: NTS
DE APPR		
DATE: 10.09.01		

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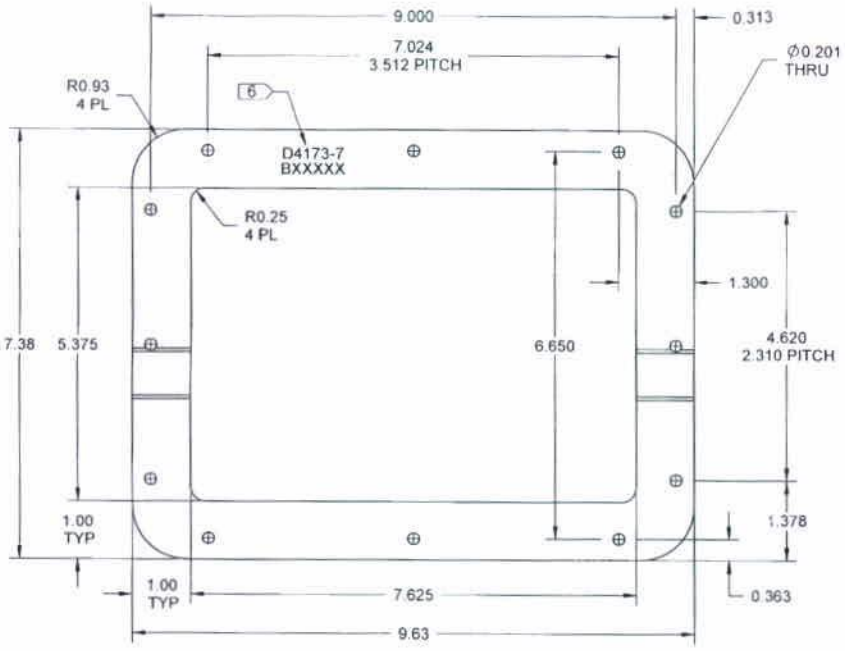

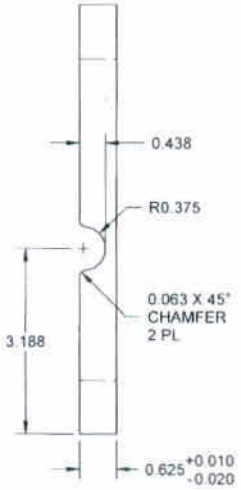

D4173-7 RADALT SHIM

61969

RELEASED
2010 -09- 29

NOTES:
1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. DART SPEC. MUHMWB
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.4
7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4173 REV. A
MFG. APPR.		SHEET 7 OF 8
APPROVED		TITLE: POD RADALT MOUNTING PLATE ASSY SCALE: NTS
DE APPR.		
DATE 10.09.01		

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